

# Work Order ID 52598



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October 2, 2009 11:21:25 AM

Item ID:	D3659-1	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	CUFF					
Start Date:	02/10/2009	Start Qty: 6.00		Cust Item ID:		
Required Date:	20/10/2009	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>RL</u>	Date:	<u>09-10-2</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3659	Rev B								
100	BAND SAW	0.00							
	Bandsaw								
Jeaspa Bandsaw	Memo Cut blank 7.300" long	0.00		<u>09.10.15</u>					
110	DOOSAN LATHE	0.00							
	Doosan								
Doosan Lathe	Memo 1-Turn as per folio FA 707 & DWG D3659, FOLIO REV: <u>11</u> DWG REV: <u>15</u> 2-Deburr as required	0.00		<u>09.10.15</u>					
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00		<u>09.10.15</u>					



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Item ID: D3659-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: CUFF

Start Date: 02/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 20/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 477

0.00



Packaging

Memo

0.00

Packaging

9/10/16 SW SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/19 AF

NF 09-10-19

# Picklist Print

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Work Order ID: 52598



Parent Item: D3659-1RevB



Parent Item Name: CUFF

Start Date: 02/10/2009

Required Date: 20/10/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6009-129RevA		Manufactured	No			100	Each	15.0000	0.3537			
Crosstube Material												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

38342

15

15

5

*N*  
*A.*  
*09-10-19*  
*09.10.15*

DART AEROSPACE LTD		Work Order: 52598
Description: <i>CUFF</i>		Part Number: D3659-1
Inspection Dwg:	Rev: 15	Page 1 of 1

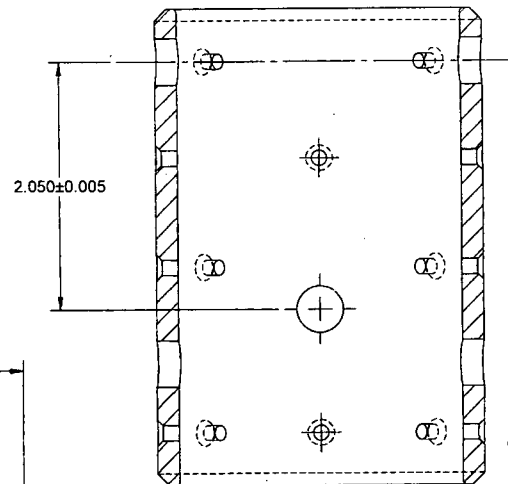
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

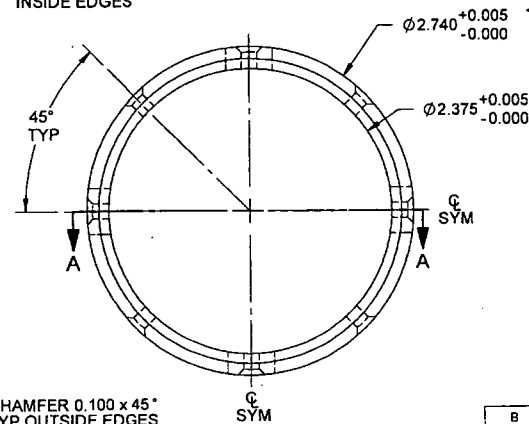
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.950	+/- .010	3.950	/			
3.075	+/- .010	3.075	/			
2.500	+/- .010	2.500	/			
1.700	+/- .010	1.700	/			
.800	+/- .010	.800	/			
.438	+/- .010	.438	/			
.128	+ .005 - .001	.128	/			
.230 x	+/- .010	.232	/			
100°	+/- 1/2°	100°	/			
.386	+ .005 - 0.0	.390	/			
2.050	+/- .005	2.050	/			
R.032	+/- .010	.032	/			
45° TYP	<del>45°</del> +/- 1/2°	45°	/			
2.740	+ .005 - 0.0	2.744	/			
2.375	+ .005 - 0.0	2.378	/			
.100 x	<del>100°</del> +/- .010	.100	/			
45°	+/- 1/2°	45°	/			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: 09.10.15	Date: 09/10/15	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

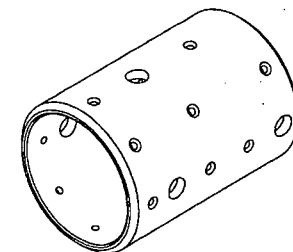


SECTION A-A  
R0.032 TYP  
INSIDE EDGES



CHAMFER 0.100 x 45°  
TYP OUTSIDE EDGES

### D3659-1 CUFF



SHOP ONLY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO A REVISION  
WITHOUT NOTICE  
WORK ORDER  
NO. 52598  
09-10-2

RELEASED

B	ADD Ø0.128 & Ø0.386 HOLES (B8)	CP	08.03.03
A	NEW ISSUE	CP	07.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>CP</i>		
CHECKED	<i>JP</i>		
MFG. APPR.	<i>ED</i>		
APPROVED	<i>JP</i>		
DE APPR.	<i>JP</i>		
DATE	08.03.03		
		SHEET 1 OF 1	
		TITLE <b>CUFF</b> SCALE <b>NAT</b>	
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DRILL #30 (Ø0.128 REF)  
C'SINK Ø0.230x100°  
TYP 22 PLACES

Ø0.386+0.005/-0.000  
HOLE TO BE ALIGNED  
WITHIN ±0.001 OF HOLE  
ON OTHER SIDE OF CUFF.  
TYP 6 PLACES

#### NOTES:

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)  
(CAN MAKE FROM D6005, D6006, D6008, D6009, D6011, OR D6019)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.56 lbs